

Work Order ID 142491

142491

Page 1

Wednesday, March 09, 2016 2:58:08 PM

Item ID: D2893-1

Revision ID:

Item Name: Support

Start Date: 3/22/2016

Required Date: 3/29/2016

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: MAR 10 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2893	C

100

0.01

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA081
2-Debur

0.10

28

Ø

DAS
20
9-89

16-03-18

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

28

Ø

DAS
20
9-89

16-03-18

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

28

Ø

DAS
44
9-89

16/03/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 142491

Wednesday, March 09, 2016 2:58:08 PM

142491

Page 2

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 3/22/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/29/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 41 9-89 16-3-23
130						28			
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.	132391							
140	QC3- Inspect Part Finish	0.00							DAS 38 9-89
140						(28)			
QC	Memo	0.00							
Quality Control									MAR 24 2016
170	Identify as per dwg & Stock Location: LG50	0.00							DAS 41 9-89 16-3-24
170						28			
Packaging	Memo	0.00							
Packaging	LOCATION : LG050								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 142491***142491***

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Wednesday, March 09, 2016 2:58:08 PM

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 3/22/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/29/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

Quality Control

MAR 29 2016

MCS

SH 20160324

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 142491

142491

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 3/22/2016

Required Date: 3/29/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C02.11.26Reformat; Added P/OKJ
IPP D 06.04.19 removed alodine EC
IPP Rev:E Added priming as per Rev B 07-04-30 JLM
IPP F 08.03.19 Re-format EC verified by: DD
IPP Rev:G 08-05-15 add QC14 DD verified by:EC
11.08.04 as per dwg rev.C DD verf:EC
IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK078		Manufactured	No			100	Each	0.0000	0.5	6.31579			
DSK078									**	14.000			DAS
D2893-1 Turning Detail													20 9-89 16-03-17

141333

14.000

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐	
Misidentified ☐	Past Due ☐																																																														

DART AEROSPACE LTD		Work Order: 142491
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.990	2.990	2.990
AB	0.440	0.460		.440	.450	.450	.450	.450
AC	0.125	0.160		.139	.136	.135	.135	.138
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.135	.136	.136	.136	.134
AG	0.140	0.160		.144	.143	.140	.140	.145
AH	1.360	1.400		1.378	1.377	1.378	1.377	1.379
AI	0.040	0.060		.053	.050	.049	.049	.053
AJ	1.190	1.230		1.223	1.220	1.224	1.219	1.225
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: <u>DAS 20</u> DAS 9-89		Date: <u>16-03-18</u>
Audited by: <u>44</u> 9-89		Date: <u>16/03/22</u>
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 142491
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6A	7A	8A	9A	10A
HAAS Section								
AA	2.985	3.005		2.990	2.990	2.990	2.990	2.990
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.138	0.138	0.138	0.138	0.138
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		0.135	0.138	0.138	0.138	0.138
AG	0.140	0.160		0.140	0.140	0.140	0.140	0.153
AH	1.360	1.400		1.378	1.377	1.377	1.379	1.379
AI	0.040	0.060		0.055	0.052	0.048	0.052	0.045
AJ	1.190	1.230		1.225	1.223	1.220	1.223	1.221
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: DAS	Date: 16/03/19
Audited by: 44 9-89	Date: 16/03/22
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	142491
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.990	2.990	2.990	2.992	2.991
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.138	0.133	0.133	0.133	0.139
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AF	0.125	0.160		0.137	0.136	0.136	0.136	0.136
AG	0.140	0.160		0.152	0.151	0.150	0.151	0.152
AH	1.360	1.400		1.379	1.379	1.379	1.380	1.379
AI	0.040	0.060		0.050	0.050	0.048	0.049	0.051
AJ	1.190	1.230		1.222	1.224	1.2215	1.221	1.224
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.532	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT				✓	✓	✓	✓	✓
Accept/Reject								

Measured by:	DAS	Date:	16/03/20
Audited by:	44 9-89	Date:	16/03/22
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 142 491
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.991	2.990	2.990	2.992	2.991
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.134	0.135	0.134	0.135	0.133
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AF	0.125	0.160		0.136	0.135	0.135	0.133	0.133
AG	0.140	0.160		0.152	0.151	0.152	0.152	0.150
AH	1.360	1.400		1.379	1.379	1.381	1.378	1.378
AI	0.040	0.060		0.051	0.050	0.049	0.052	0.051
AJ	1.190	1.230		1.223	1.223	1.223	1.223	1.223
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: DAS	Date: 16/03/21
Audited by: 44 9-89	Date: 16/03/22
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 142 491
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	25
HAAS Section								
AA	2.985	3.005		2.992	2.992	2.991	2.996	2.993
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.140	0.136	0.136	0.136	0.138
AD	0.040	0.060		0.050	0.050	0.050	0.053	0.0485
AE	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AF	0.125	0.160		0.134	0.135	0.136	0.135	0.136
AG	0.140	0.160		0.154	0.150	0.151	0.154	0.1435
AH	1.360	1.400		1.378	1.380	1.378	1.380	1.3785
AI	0.040	0.060		0.050	0.050	0.051	0.050	0.052
AJ	1.190	1.230		1.2215	1.223	1.2225	1.221	1.223
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

DAS

Measured by: 20	Date: 16-03-22
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DAS 9-89

Audited by: 44	Date: 16/03/22
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9-89

Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

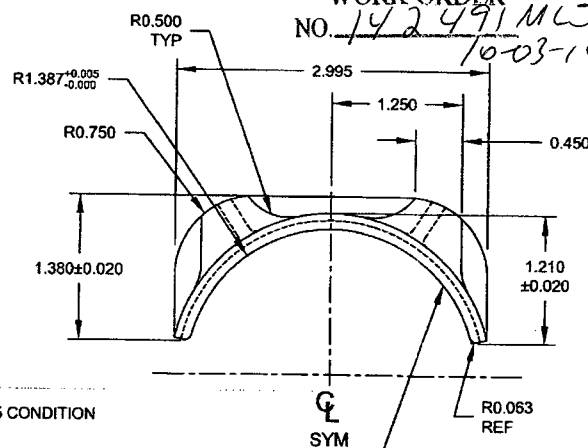
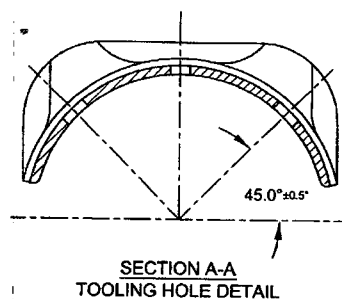
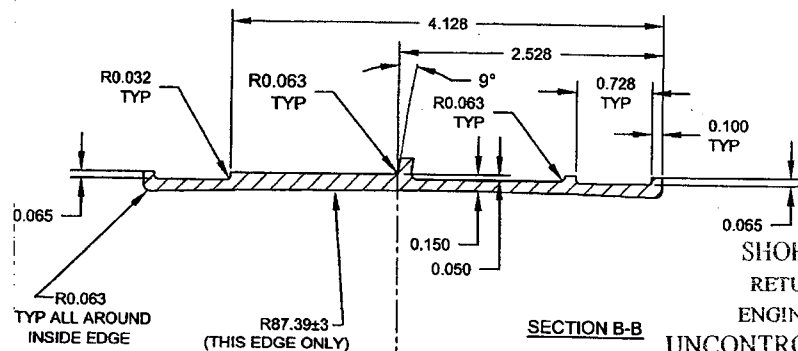
DART AEROSPACE LTD		Work Order: 142 491
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26	27	28		
HAAS Section								
AA	2.985	3.005		2.993	2.992	2.992		
AB	0.440	0.460		0.450	0.450	0.450		
AC	0.125	0.160		.138	.138	.137		
AD	0.040	0.060		.051	.050	.051		
AE	0.188	0.193		0.190	0.190	0.190		
AF	0.125	0.160		.137	.137	.136		
AG	0.140	0.160		.151	.147	.149		
AH	1.360	1.400		1.380	1.380	1.377		
AI	0.040	0.060		.051	.053	.049		
AJ	1.190	1.230		1.224	1.225	1.220		
AK	0.010	0.020		0.010	0.010	0.010		
AL	0.053	0.073		0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250		
AN	2.518	2.538		2.528	2.528	2.528		
AO	84.39	90.39		87.39	87.39	87.39		
AP	0.261	0.266		0.261	0.261	0.261		
AQ	0.053	0.073		0.063	0.063	0.063		
AR								
AS								
AT								
Accept/Reject								

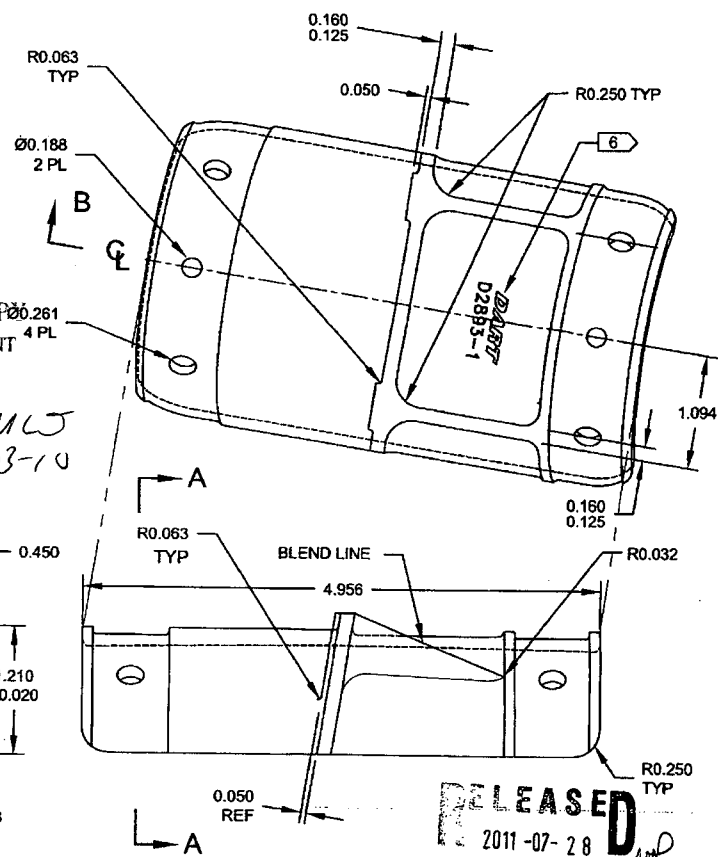
Measured by: DAS 20	Date: 16-03-22
Audited by: 44	Date: 16/03/22
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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NO. 142491MLJ
10-03-10

D2893-1 SUPPORT



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF XXXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

RELEASED
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Q</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2893	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	Ø2.750 SUPPORT	NTS
DATE	11.07.15	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	